

Work Order ID 80636-2

February-24-12 3:22:10 PM

23mm

\*80636\*

Page 1

Item ID: D350-567-141

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

split 9

Stop

\*NS2\*

Item Name: Floor Window Closeout Installation

Start Date: 24/02/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan: M.L.5

Date: 12/02/27

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9590	A B	EN 12-537							
100	DOCUMENT CONTROL	0.00							
*100*									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D350-567-141 CHG001								
110	Pick Kit	0.00							
*110*									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

W 12.03.23 (9)

After M.L.5 12-3-14 (10)

12/3/13 (9) sp

W 12 03 23 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80636**

February-24-12 3:22:10 PM

**\*80636\***

Page 2

Item ID: D350-567-141

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Window Closeout Installation

Start Date: 24/02/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-567-141  
Location: \_\_\_\_\_

12/3/23 (9x)

140

0.00

**\*140\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

MLJ 12/03/23

mf  
12-03-23



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# Picklist Print

February-24-12 3:22:13 PM

Page 1

Work Order ID: 80636

\*80636\*

Parent Item: D350-567-141

\*D350-567-141\*

Parent Item Name: Floor Window Closeout Installation

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM  
12.01.23 AS PER ECN12-511 DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3802-1		Manufactured	No			110	f	554.3800	2	20			
*D3802-1*									**				
Window Seal													

Location	Loc Qty	Loc Code
----------	---------	----------

ST412	554.38	
56881	554.38	

(D3802-1-024) CUT (I) AT 24" AS PER DWG, PER KIT.

D4434-041	Manufactured	No			110	Each	0.0000	1	10				
-----------	--------------	----	--	--	-----	------	--------	---	----	--	--	--	--

\*D4434-041\*

Fwd Bracket Assembly

D4434-047	Manufactured	No			110	Each	3.0000	1	10				
-----------	--------------	----	--	--	-----	------	--------	---	----	--	--	--	--

\*D4434-047\*

Cover Assembly

Location	Loc Qty	Loc Code
----------	---------	----------

PRE	2	
77915	1	
79381	1	
prelim	1	
74814	1	

D4435-045	Manufactured	No			110	Each	2.0000	1	10				
-----------	--------------	----	--	--	-----	------	--------	---	----	--	--	--	--

\*D4435-045\*

T/R Bellcrank Cover Assembly

Location	Loc Qty	Loc Code
----------	---------	----------

ENG	2	
77926	1	
79382	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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February-24-12 3:22:13 PM

Page 2

Work Order ID: 80636

\*80636\*

Parent Item: D350-567-141

\*D350-567-141\*

Parent Item Name: Floor Window Closeout Installation

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

whl  
xg

D4435-9

Manufactured No

110 Each

4.0000

2

20

\*\*

B80659

sl

h

\*D4435-9\*

Bracket

Location

Loc Qty

Loc Code

ENG

4

77927

2

79383

2

whl  
xg

D4436-041

Manufactured No

110 Each

1.0000

1

10

\*\*

B80641

sl

h

\*D4436-041\*

Aft Bracket Assembly

Location

Loc Qty

Loc Code

ENG

1

77907

1

whl  
xg

D4441-1

Manufactured No

110 f

24.7270

2

20

\*\*

B80763

sl

h

\*D4441-1\*

Rubber Seal

Location

Loc Qty

Loc Code

prelim

24.727

74760

24.727

measured  
5/2/16

whl  
xg

(D4441-1-240) CUT (1) AT 24.00" PER KIT

AN3-3A

Purchased No

110 Each

1,007.000

7

70

\*\*

12/3/16

sl

h

\*AN3-3A\*

Bolt

Location

Loc Qty

Loc Code

ST350

1007

120187

7

120423

1000

whl  
xg

AN525-632R6

Purchased No

110 Each

0.0000

\*\*

70

2 90 20

12/3/16

sl

h

\*AN525-632R6\*

Screw

832 R7

11/20/19

February-24-12 3:22:13 PM

Shop Packet Print

Page 2



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

February-24-12 3:22:13 PM

Work Order ID: 80636

\*80636\*

Parent Item: D350-567-141

\*D350-567-141\*

Parent Item Name: Floor Window Closeout Installation

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN525-10R6

Purchased

No

110

Each

58.0000

2

20

~~\*AN525-10R6\*~~

Screw

\*\*

Location

Loc Qty

Loc Code

ST345

32

120308

32

ST346

26

118757

23

119309

3

110

Each

542.0000

9

90

\*\*

MS21042L06

Purchased

No

~~\*MS21042L06\*~~

Nut

Location

Loc Qty

Loc Code

ST300

542

118354

2

119109

39

119758

1

120360

500

110

Each

4,110.000

5

50

\*\*

MS21042L3

Purchased

No

~~\*MS21042L3\*~~

Nut

Location

Loc Qty

Loc Code

ST300

4110

117441

16

117885

32

118451

5

118927

3

119017

3854

119075

200

February-24-12 3:22:14 PM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Work Order ID: 80636

\*80636\*

Parent Item: D350-567-141

\*D350-567-141\*

Parent Item Name: Floor Window Closeout Installation

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

MS21059L3

Purchased

No

110

Each

252.0000

2

20

\*MS21059L3\*

Nut Plate

\*\*

## Location

## Loc Qty

## Loc Code

ST301

52

118614

8

119546

44

ST302

200

120308

200

110

Each

416.0000

12

120

NAS1149F0332P

Purchased

No

\*NAS1149F0332P\*

WASHER

\*\*

## Location

## Loc Qty

## Loc Code

ST275

416

117735

37

119225

176

120498

200

17317

3

110

Each

1,191.000

9

90

NAS1149FN616P

Purchased

No

\*NAS1149FN616P\*

WASHER

\*\*

## Location

## Loc Qty

## Loc Code

ST275

1191

117317

191

120560

1000

90

816 MF 12-03-20

M121039 sf

per Kit sf

per Kit sf

" " sf 20x 12/3/16

NAS1149FN616P x 2

MS35206-229 x 7

MS21042L08 x 2

B 121039

# M121039

M12042

February-24-12 3:22:14 PM

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Page 4

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W/O: 80036		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		NTS1149 FN 616P M 117317 45x	SD	12/13/23		WHL 120323	WHL 120323

Part No: D350-567-141 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D OR EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1 OR EARLIER

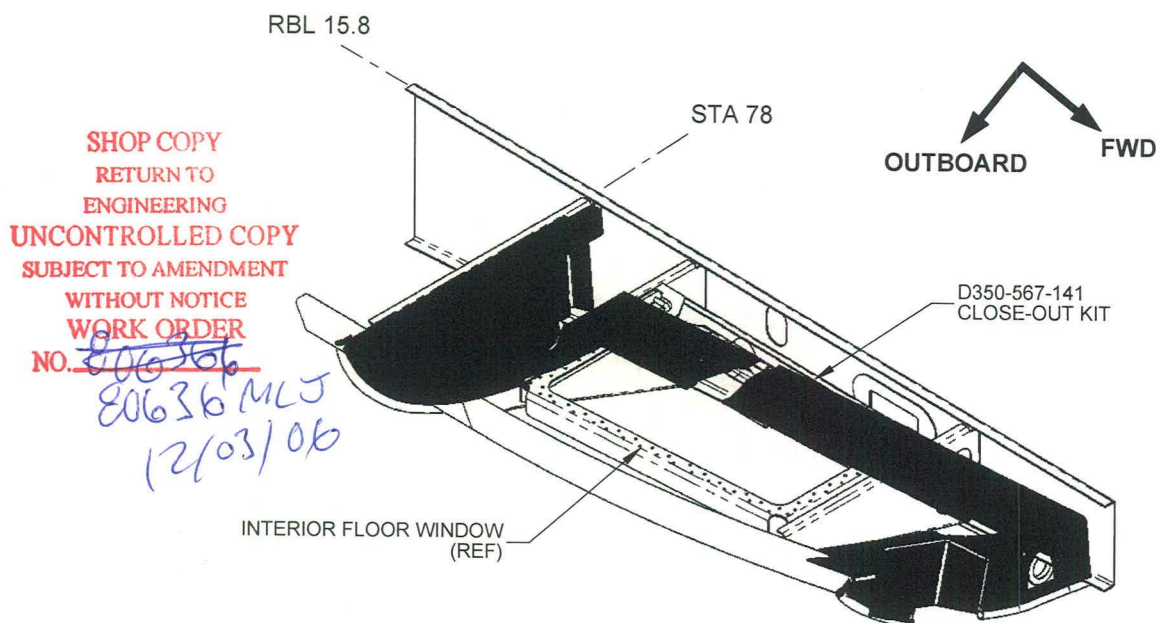
REF CANADIAN STC: SH92-18

FAA STC: SH989NE

FAA STC: SH990NE

## 1.0 Purpose

The purpose of this service instruction is to add the D350-567-141 Close-out Kit, which is intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141 Floor Window Close-out Kit provides a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1.



**Figure 1. Floor Window Close-out Kit Installation**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 12.02.22  
CERT. NO.: SH92-18  
ISSUE NO.: 6

B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>MP</u>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 12
APPROVED	<u>MP</u>	TITLE	SCALE
DE APPR.	<u>MP</u>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	12.02.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

## 2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN882P	WASHER (OR AN960-8L)

20636

B

B

B

## 3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

## 4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
  - D350-567-115 — OK to remove D3295-041
  - D350-567-031 — OK to remove D3212-1
  - D350-567-011 — OK to remove D2214
  - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 12.02.22  
CERT. NO.: SH92-18  
ISSUE NO.: 6

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DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 12
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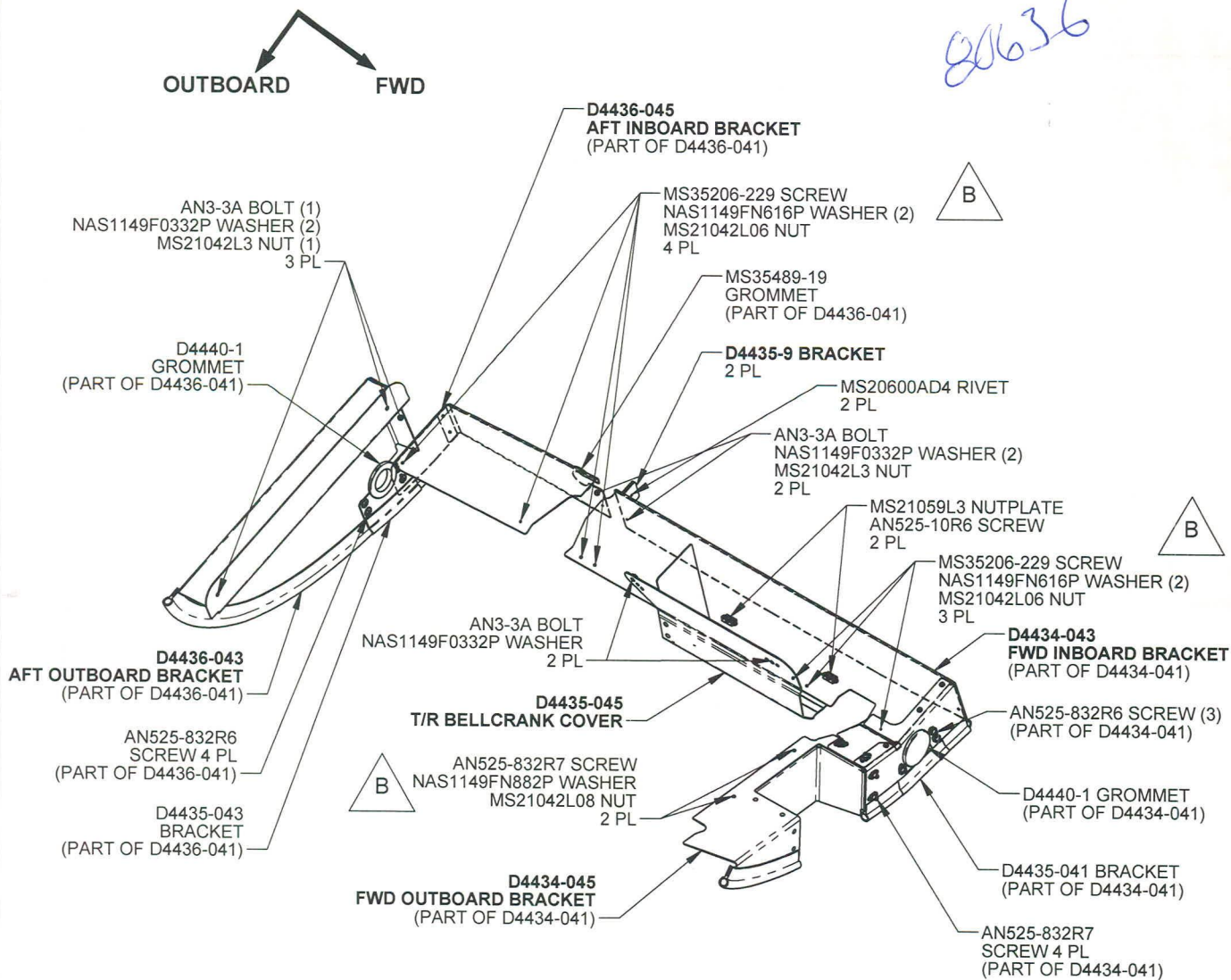
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80636



**Figure 2. Floor Window Close-out Kit Installation**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 12.02.22  
CERT. NO.: SH92-18  
ISSUE NO.: 6

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	<b>DSI 9590</b>	SHEET 3 OF 12
APPROVED		TITLE	SCALE
DE APPR.		<b>FLOOR WINDOW CLOSE-OUT KIT</b>	NTS
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80636

- 4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or clecos clamps. Before drilling holes:
  - a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
  - b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- 4.2 Temporarily install D4434-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.
- 4.3 If aircraft is equipped with Collective Circuit Breaker Board box trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4434-047 Cover as shown in Figure 13. Note: Confirm the D4434-047 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.4 Drill off rivets holding plastic wire bundle stand offs. Transfer drill  $\varnothing 0.144$  holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x  $\varnothing 0.144$  holes to D4434-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x  $\varnothing 0.144$  holes for D4434-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- 4.5 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.
- 4.6 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x  $\varnothing 0.129$  holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- 4.7 Drill a pilot hole from D4435-9 Bracket to the D4434-045 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to  $\varnothing 0.191$ . Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- 4.8 Transfer drill 2 x  $\varnothing 0.144$  holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x  $\varnothing 0.144$  holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 Screws, NAS1149FN882P washer and MS21042L08 nuts.
- 4.9 Align D4435-045 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12.
- 4.10 Transfer drill 2 x  $\varnothing 0.098$  holes from D4435-045 T/R Bellcrank Cover to D4434-043 Fwd Inboard Bracket. Open holes to  $\varnothing 0.191$  and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12 and Figure 13. Install D4435-045 T/R Bellcrank Cover using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12 and Figure 13.
- 4.11 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.12 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.13 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.14 Ensure there is a gap between the components of the D350-567-141 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-041 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.



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AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 12.02.22  
CERT. NO.: SH92-18  
ISSUE NO.: 6

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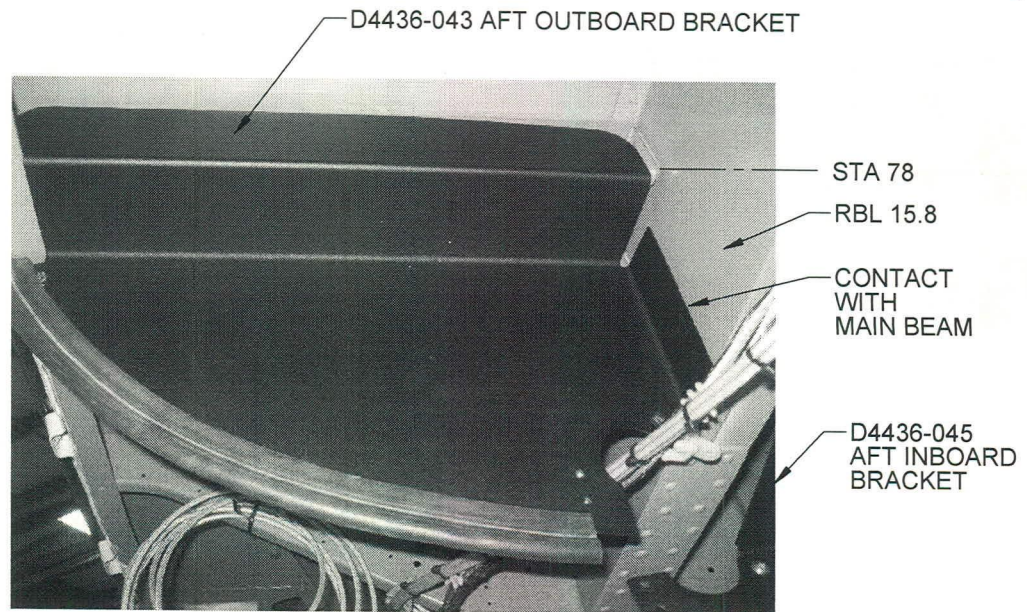
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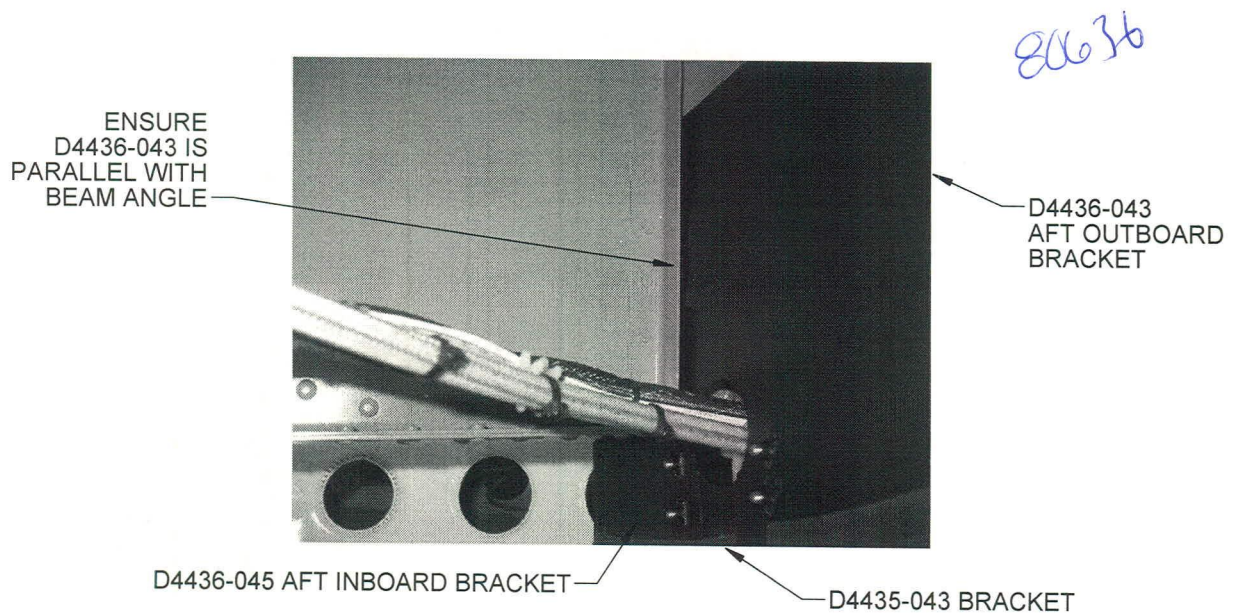
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**Figure 3. D4436-043 Aft Outboard Bracket Installation**



**Figure 4. D4436-043 & D4435-043 Brackets Installation**

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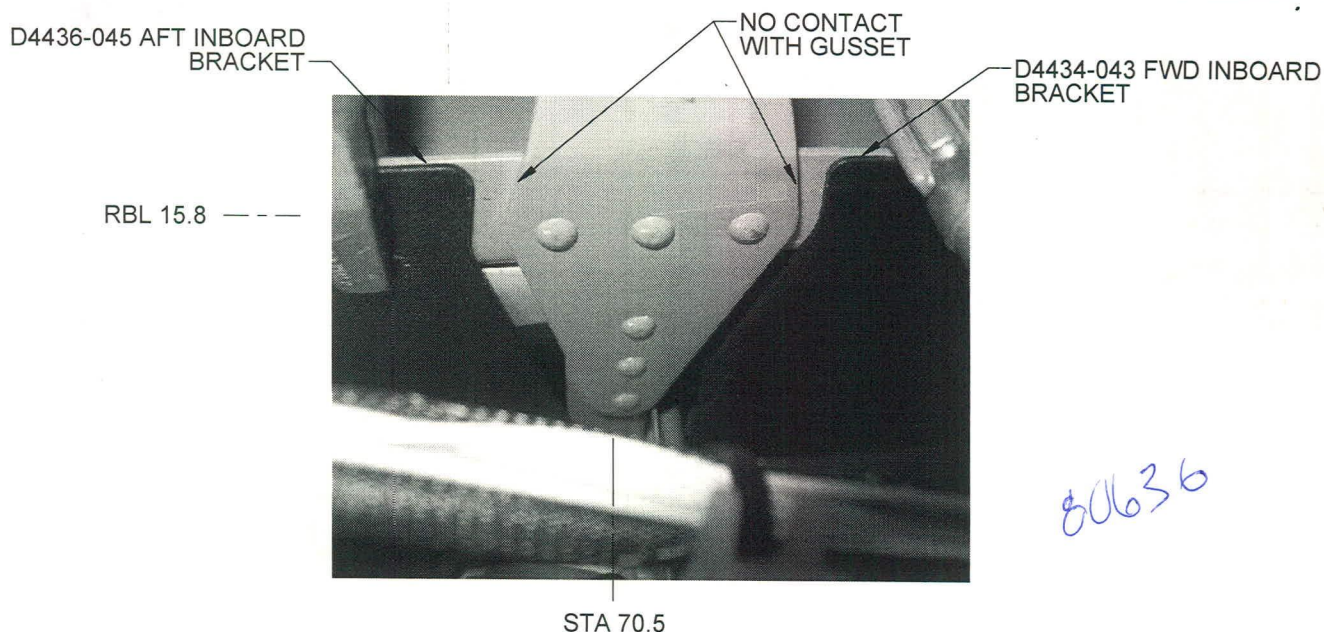
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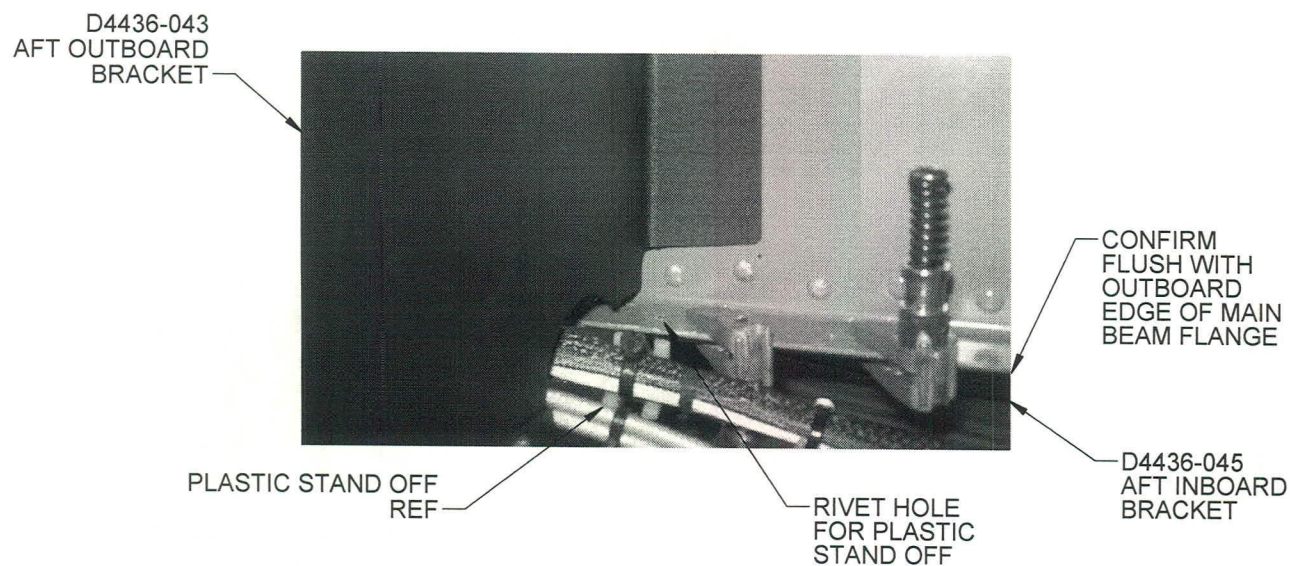
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**Figure 5. D4436-045 & D4434-043 Brackets Installation**



**Figure 6. D4436-043 & D4436-045 Brackets Installation**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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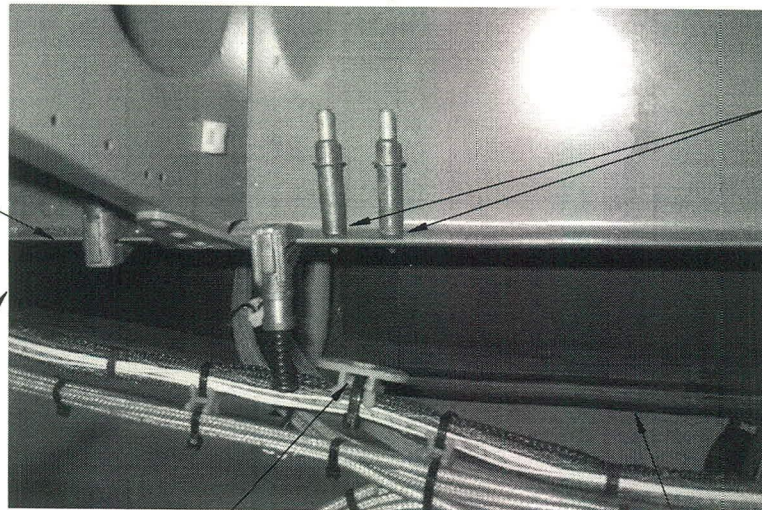
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CONFIRM  
FLUSH WITH  
OUTBOARD  
EDGE OF MAIN  
BEAM FLANGE

D4436-045  
AFT INBOARD  
BRACKET

PLASTIC STAND OFF  
REF



RIVET HOLES  
FOR PLASTIC  
STAND OFF

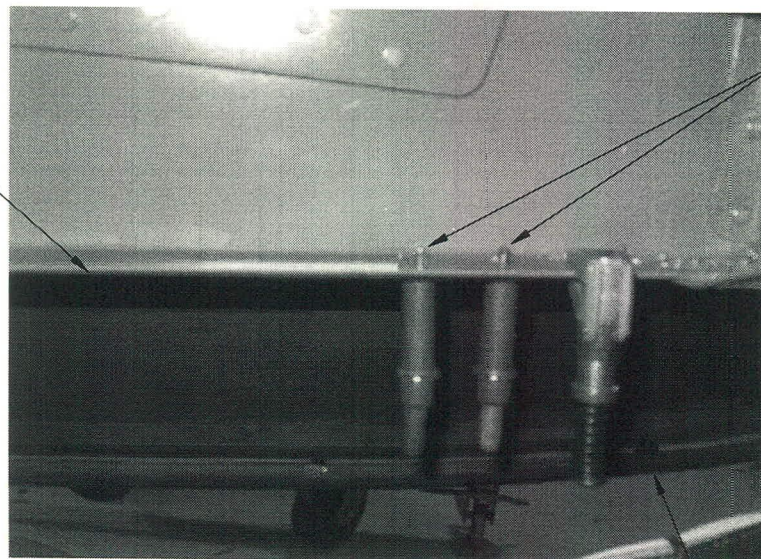
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D4434-043 FWD INBOARD  
BRACKET

80636

**Figure 7. D4434-043 & D4436-045 Brackets Installation**

CONFIRM  
FLUSH WITH  
OUTBOARD  
EDGE OF MAIN  
BEAM FLANGE



RIVET HOLES  
FOR PLASTIC  
STAND OFF

--- RBL 15.8

D4434-043 FWD INBOARD  
BRACKET

**Figure 8. D4434-043 Fwd Inboard Bracket Installation**

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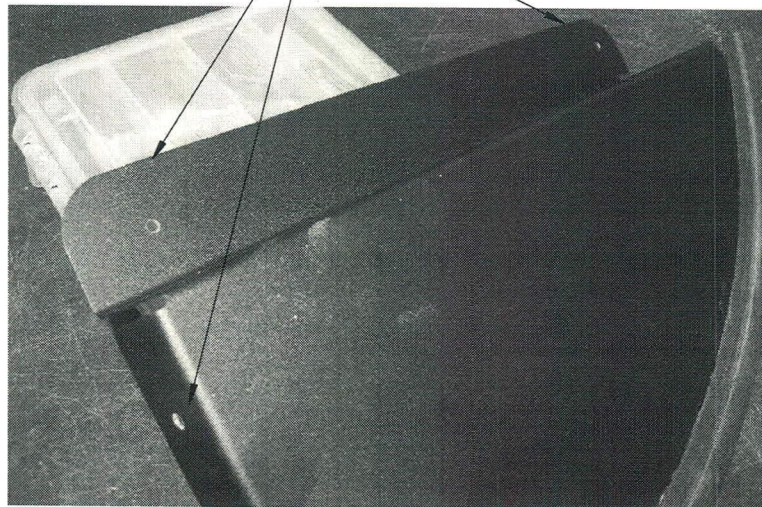
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

INSTALL  
D4436-043  
AFT OUTBOARD BRACKET  
USING  
AN3-3A BOLT (1)  
NAS1149F0332P WASHER (2)  
MS21042L3 NUT (1)  
3 PL

80636



**Figure 9. D4436-043 Aft Outboard Bracket Installation**

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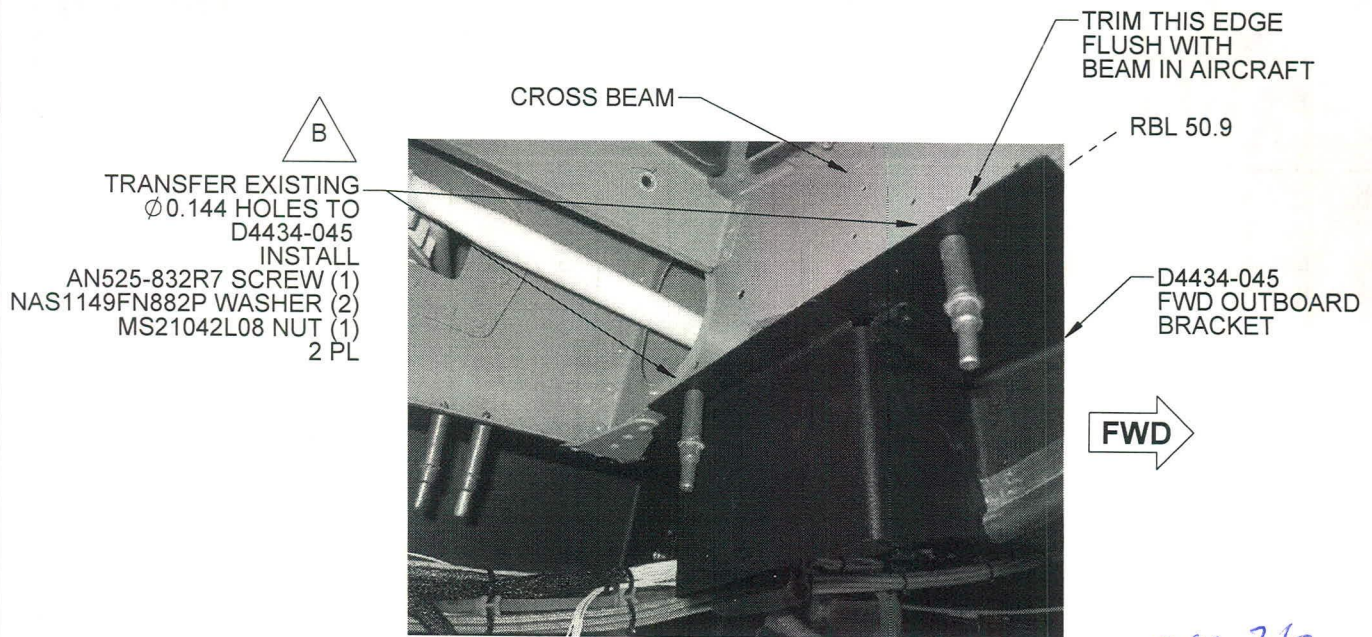
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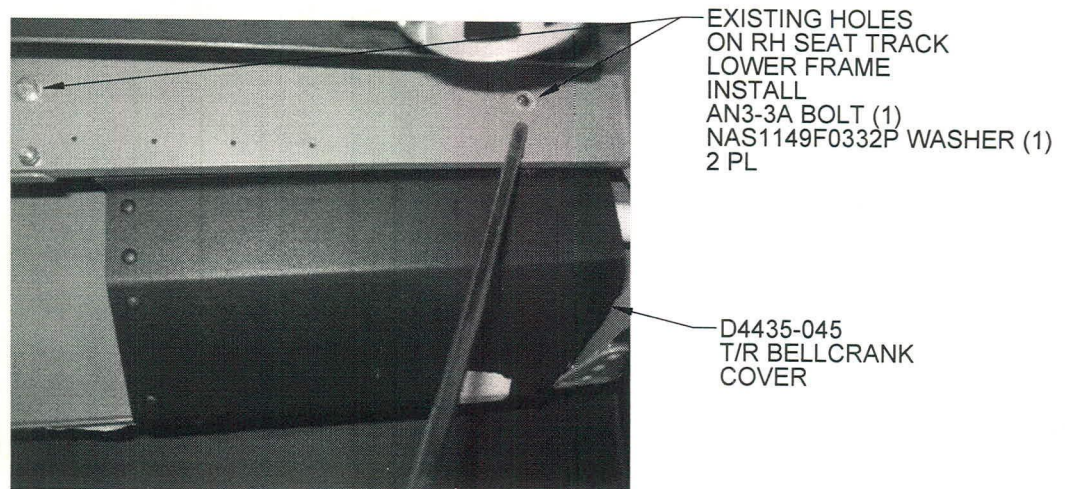
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**Figure 11. D4434-045 Bracket Installation**



**Figure 12. D4435-045 T/R Bellcrank Cover Installation**

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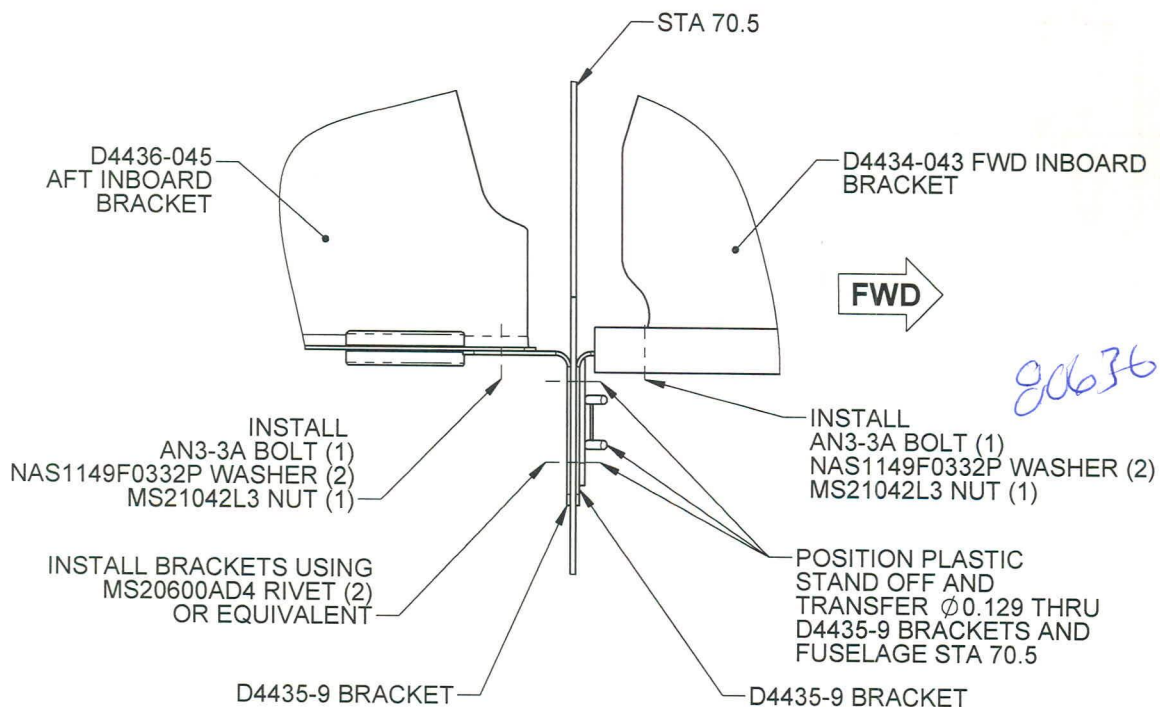
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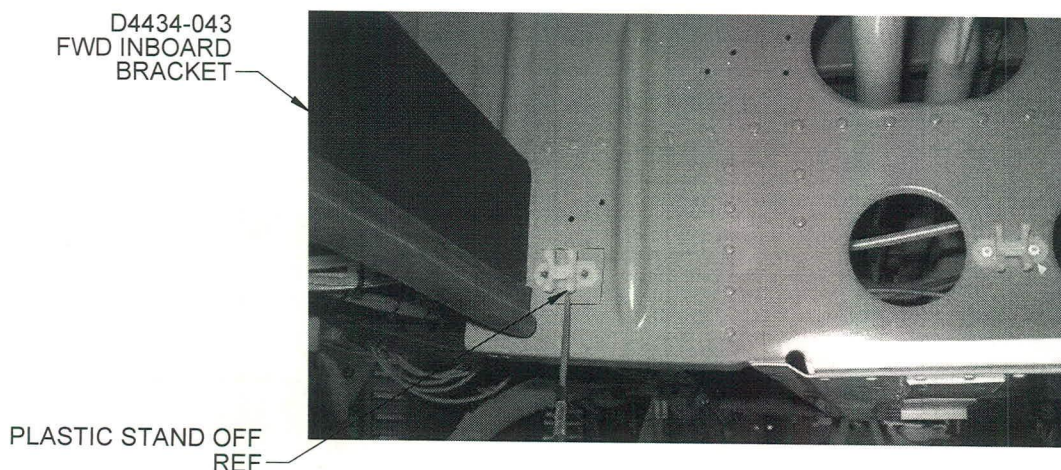
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**LOOKING UP AT STA 70.5**



**Figure 10. D4434-043 and D4435-9 Brackets Installation**

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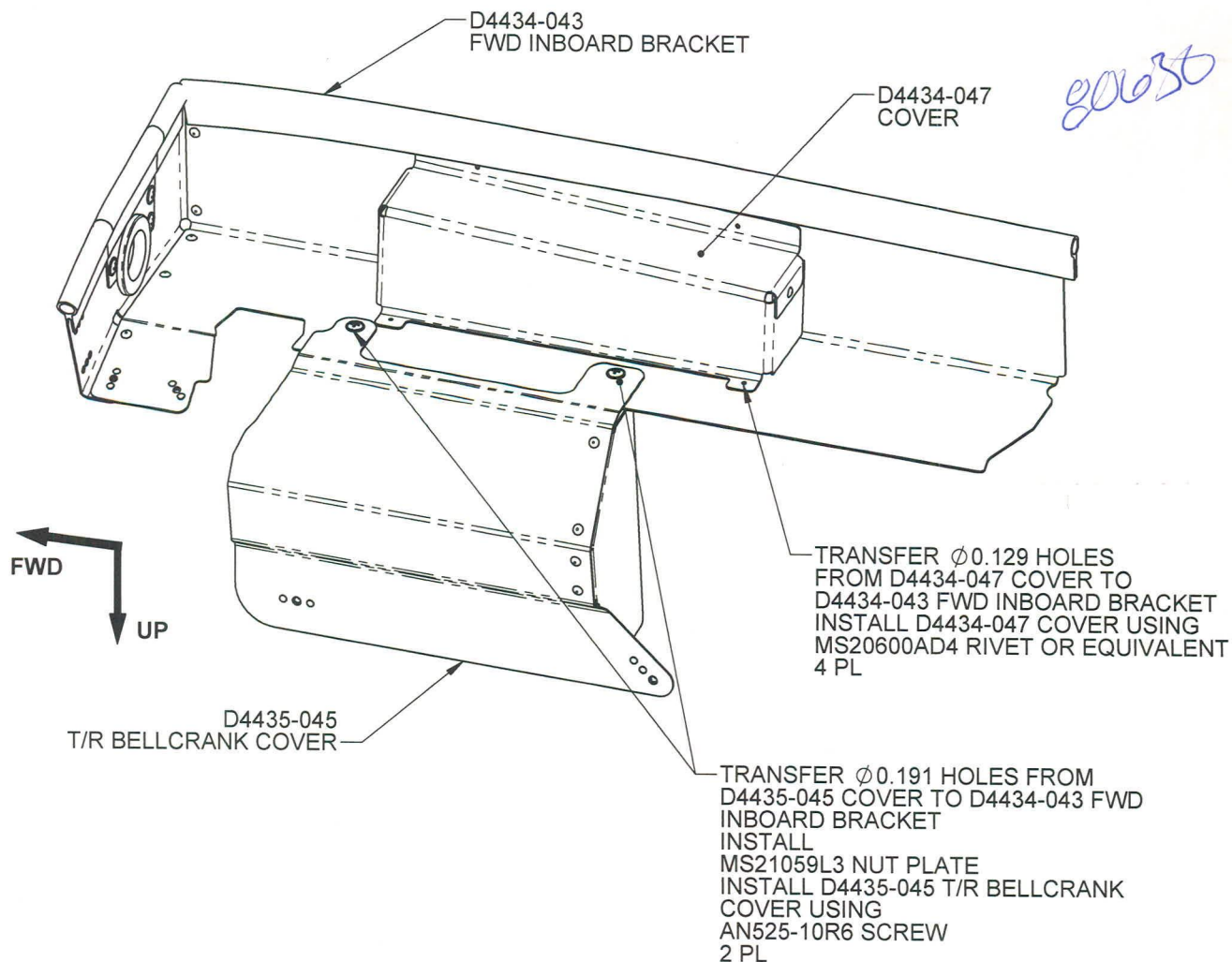
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**Figure 13. D4435-045 & D4434-047 Cover Installation**

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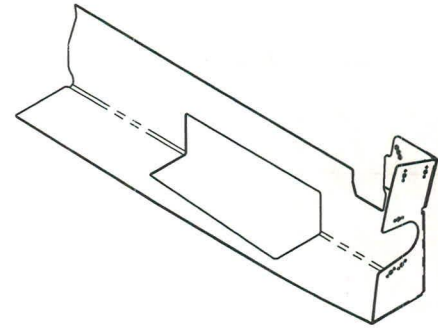
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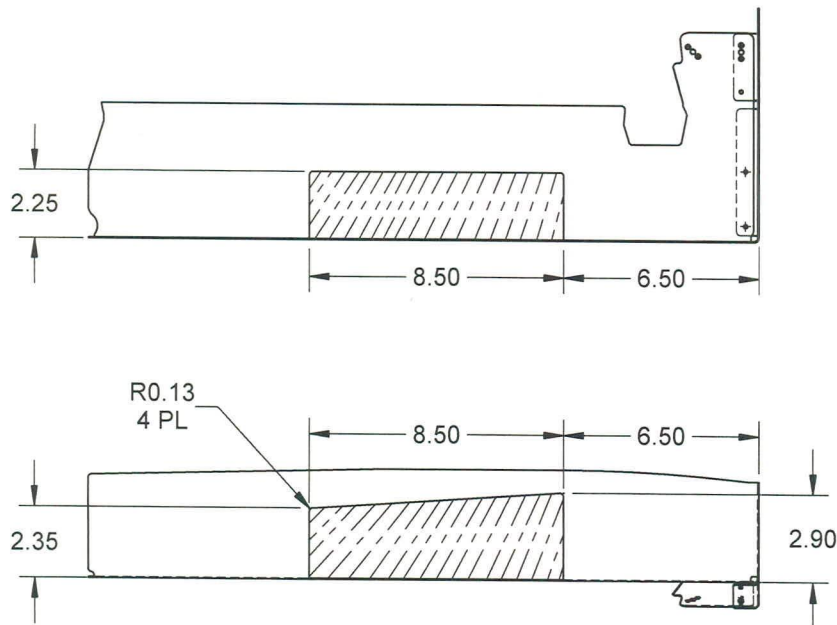
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**Figure 14. D4434-043 Fwd Inboard Bracket Cutout**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELL CRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN882P	WASHER (OR AN960-8L)

## 3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

## 4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
  - D350-567-115 — OK to remove D3295-041
  - D350-567-031 — OK to remove D3212-1
  - D350-567-011 — OK to remove D2214
  - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

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BY:   
D. SHEPHERD (DE # 02)

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. REV. B
MFG. APPR.	N/A	DSI 9590 SHEET 2 OF 12
APPROVED		TITLE SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT NTS
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## Change Record

Part Number D350-567-141

Page 1 of 1

Description FLOOR CLOSEOUT WINDOW INSTALLATION

[illegible]

